

\* Reprint \*

Work Order ID 106147

\*106147\*

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September-11-13 9:55:59 AM

Item ID: D2617-3 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Bushing  
Start Date: 30/09/2013 Start Qty: 30.00 \*30\* Cust Item ID:  
Required Date: 30/09/2013 Req'd Qty: 30.00 \*30\* Customer:  
Reference: *13.09.11*  
Approvals: Process Plan: *13.09.11* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2617	Rev D2								

100 Hardinge CNC LATHE SMALL 0.00  
\*100\*  
Hardinge Memo 0.00 *DAS 40 9-89 13/09/12* 30 Ø  
Hardinge CNC Lathe Small Turn as per Folio FA437 and Dwg D2617

110 QC2- Inspect parts off machine FAI/FAIB 0.00  
\*110\*  
QC Memo 0.00 *DAS 40 9-89 13/09/12* 30 Ø  
Quality Control

120 QC8- Inspect parts - second check 0.00  
\*120\*  
QC Memo 0.00 *D.A 13/09/13* 30 Ø *DAS 08 9-89*  
Quality Control

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Item ID: D2617-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bushing  
 Start Date: 30/09/2013 Start Qty: 30.00 **\*30\*** Cust Item ID:  
 Required Date: 30/09/2013 Req'd Qty: 30.00 **\*30\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
<b>*130*</b>	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr break all unmarked sharp edges 0.005 to 0.010	0.005 to 0.010							
135	QC5- Inspect part completeness to step on W/O	0.00							
<b>*135*</b>	QC	0.00							
Quality Control	Memo	0.00							
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>	HandFinish	0.00							
Hand Finishing	Memo	0.00							

30 13-9-23

# Work Order ID 106147

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September-11-13 9:56:01 AM

Item ID: D2617-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bushing  
 Start Date: 30/09/2013 Start Qty: 30.00 \*30\* Cust Item ID:  
 Required Date: 30/09/2013 Req'd Qty: 30.00 \*30\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				30			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST013</u>  Memo	0.00  0.00				30X		13-09-24	
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*[Handwritten signature]* / Rm 13/09/25

*[Handwritten signature]* 13-09-24

# Picklist Print

September-11-13 9:55:41 AM

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Work Order ID: 106147

Parent Item: D2617-3

Parent Item Name: Bushing

Start Date: 30/09/2013

Required Date: 30/09/2013

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP G04.07.14Reformat; added step 5KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 6061-T6 RD Tube .375 x.058W		Purchased	No			100	f	273.8680	0.0729	2.302104			

*DAS*  
*40*  
*9-89*  
*13/09/12*

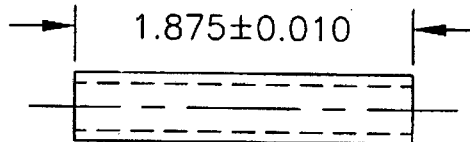
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT014	273.868	
116920	1.156	
119087	0.11	
123303	8	
123449	16.336	
124069	8.266	
<i>→</i> M126335	240	

*2.4*

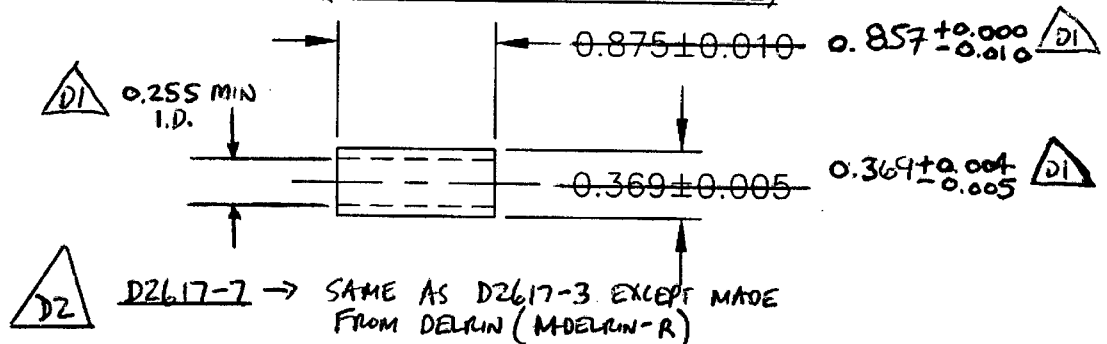
**DART**

DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04				TITLE BUSHING	SCALE 1:1
DZ	04.09.10	CP	ADD D2617-7	A	96.10.08 NEW ISSUE
				B	97.05.08 .875 WAS 1.125
				C	97.06.04 0.369 DIA WAS 0.375
				D	01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE
				DI	04.07.12 CORRECT TOLERANCE (NCR 779)

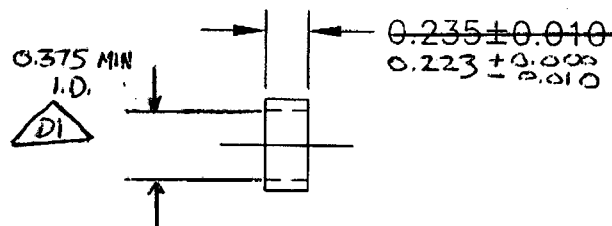
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



**RELEASED**  
01.07.05

#### NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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